



Department of Mechanical and Manufacturing Engineering

**OUTWARD CURVATURE RUNNER WITH AIR VENTS FOR DIE
CASTED TEST PIECE BASED ON MANUFACTURABLE MOLD
DESIGN**

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(Mechanical and Manufacturing Engineering)**

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OUTWARD CURVATURE RUNNER WITH AIR VENTS FOR DIE CASTED TEST
PIECE BASED ON MANUFACTURABLE MOLD DESIGN

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A dissertation submitted in partial fulfillment
of the requirement for the degree of
Bachelor of Engineering with Honours
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Faculty of Engineering
Universiti Malaysia Sarawak

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Dedicated to My Beloved Family and Friends.

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ABSTRACT

Die casting is a manufacturing process used to produce complex and precise products where molten material is injected into the mold cavity at a very high speed and pressure. Metal injection molding manufacturing is gradually increasing due to the demand for lightweight and sustainable material. Magnesium has several unique physical properties that are comparable with Aluminum metal. In this research, the objective is to study the effect of modification on runner and installation of air vents in reducing investigated defects location. The design of the cavity in this project is a ‘test piece’, an inspection instrument. Design modeling and the relevant parameter is input into ANSYS software for numerical simulation. Novelty runner and gate design (Outward curvature runner with air vent) to enhance fluid behavior inside the cavity are discussed in this paper. Effect of inserting different plunger speed and inserting vacuum also found in this research study. Found that, the modified design could improve the distribution of velocity and temperature of molten metal inside the mold cavity. The modified design also have optimized the fluid flow and eliminate the vortex formation.

ABSTRAK

Die casting adalah proses pembuatan yang digunakan untuk menghasilkan produk yang kompleks dan bertepatan dengan reka bentuk yang diinginkan. *Die casting* merupakan proses di mana logam yang dileburkan akan dimasukkan ke rongga acuan pada kelajuan dan tekanan yang sangat tinggi. Pemintaan produk logam yang ringan dan dihasilkan melalui proses *Die Casting* meningkat dari tahun ke tahun. Magnesium mempunyai beberapa ciri fizikal unik yang boleh dibandingkan dengan logam aluminium. Objektif kajian ini adalah untuk mengkaji kesan pengubahsuaian reka bentuk acuan dan pemasangan laluan udara pada acuan asal dalam mengurangkan kecacatan yang diselidiki. Proses pembuatan '*Test Piece*' melalui proses *Die Casting* merupakan fokus utama kajian ini, '*Test Piece*' merupakan sebuah instrumen yang digunakan untuk mengukur. Simulasi akan dijalankan pada rekabentuk acuan yang telah diubah dan parameter yang relevan akan digunakan sebagai input dalam perisian ANSYS. Kebolehan rekabentuk acuan yang telah diperbaharui (*Outward curvature runner with air vents*) dalam meningkatkan sifat bendalir di dalam acuan akan dibincangkan dalam karya ini. Penyelidikan ini juga merangkumi kesan kelajuan pergerakan logam yang berbeza dan tekanan rendah terhadap sifat logam lebur di dalam acuan. Didapati bahawa reka bentuk yang telah diubah suai dapat mengoptimumkan pengagihan halaju dan suhu logam lebur di dalam acuan. Reka bentuk yang diubah suai juga turut mengoptimumkan aliran bendalir dan menghapuskan pembentukan pusaran.

TABLE OF CONTENTS

Dedication	i
Acknowledgement	ii
Abstract	iii
Abstrak	iv
Table of Contents	v
List of Tables	viii
List of Figures	ix
List of Abbreviations	xiv
 CHAPTER 1 INTRODUCTION	 1
1.1 Background of Study	1
1.1.1 Market Demand on MIM Machine	3
1.1.2 Magnesium Metal and Alloys	4
1.2 Test Piece	5
1.3 V-LINE®SYSTEM	6
1.4 Problem Statement	10
1.5 Objectives of Research	11
1.6 Scope of Research	11
1.7 Organization of Thesis	12
CHAPTER 2 LITERATURE REVIEW	13
2.1 Introduction	13
2.2 Vacuum Die Casting	13
2.3 Die Casting Defects	14
2.3.1 Gas Porosity	14
2.3.2 Shrinkage Porosity	14
2.3.3 Leaker	14
2.3.4 Misrun	14
2.4 Porosity Factors	15
2.4.1 Turbulent Fluid Flow	15
2.4.2 Microstructure of Alloy	16

2.4.3	Huge Thermal Difference	16
2.4.4	Low Injection Volume	16
2.4.5	Gas Absorption during Metal Melting	17
2.5	Porosity Effects	17
2.6	Porosity Reduction	18
2.7	Mold Modification	19
2.7.1	Generating Curve at The Cavity Edge	19
2.7.2	Runner Optimization	20
2.7.3	Chill Vent Installation	22
2.7.4	Gating System	23
2.8	Molten Metal	25
2.8.1	Magnesium Cast	25
2.8.2	Biodegradable Magnesium Alloys Application	27
2.8.3	Aluminium Alloy ADC12 Cast	28
2.9	Computer Simulation Software	29
CHAPTER 3	METHODOLOGY	30
3.1	Introduction	30
3.2	Design Process	30
3.2.1	Problem Statement	32
3.2.2	Gathering information	32
3.2.3	Concept Generation	32
3.2.4	Analyse the Concept	32
3.2.5	Analyse the System	33
3.2.6	Design Optimization and Modification	34
3.3	Mold Design	34
3.4	Simulation of the Experiment	38
CHAPTER 4	RESULTS AND DISCUSSION	44
4.1	Introduction	44
4.2	Runner and Air Ventilation System	44
4.2.1	Biscuit	46
4.2.2	Cavity	46
4.2.3	Overflow	46
4.2.4	Air Vent	46

4.2.5	Runner	46
4.3	Analysis of Molten Metal Flow	51
4.4	MG-Plus Method Injection Molding	55
4.5	Casting Defects Analysis	56
4.6	Simulation Analysis	57
4.6.1	Comparison of Velocity Streamlines Distribution	60
4.6.2	Comparison of Total Temperature Distribution	62
4.6.3	Comparison of Outward Curvature Runner with Air Vents Mold Design with Conventional ADC12	66
4.6.4	Turbulence Effect Based on Different Plunger Speed	67
4.7	High Vacuum Die Casting	69
CHAPTER 5	CONCLUSION	70
5.1	Introduction	70
5.2	Conclusions	70
5.3	Recommendation	71
REFERENCES		72

LIST OF TABLES

Table	Page
1.1 Main Components and Function of Thixomolding	2
1.2 V-LINE®System Characteristic	7
1.3 V-LINE®System Machine Specification for ALM 450 and MP450	8
2.1 Weight and Porosity of Parts Produced at Various Injection Screw Velocities	18
2.2 Comparison of Aluminium and Magnesium Properties	26
2.3 ADC12 Parameters	28
3.1 Parameter of Molten Metal Flow Simulation	37
4.1 Skewness Quality	49
4.2 Parameters of Flow Simulation	51

LIST OF FIGURES

Figure		Page
1.1	Schematic Drawing of Thixomolding® Machine	2
1.2	U.S. MIM Market by End-use, 2014 - 2025 (USD Million)	3
1.3	MIM Market Share by End-use on the Year 2015	3
1.4	Test Piece	5
1.5	Test Piece Venting System	5
1.6	Nozzle Separation in V-LINE®System	6
1.7	ALM 450 V-LINE® Direct Casting Mechanism	9
1.8	MG-Plus Method	9
2.1	(a) Original Model, (b) Vacuum System Model	13
2.2	(a) Original Model,(b) 1st Corrected Model,(c) 2nd Corrected Model	15
2.3	(a) Effect of Porosity on Ultimate Tensile Strength (b) Tensile Yield Strength	17
2.4	Curve Generated	19
2.5	Elements of the Die Casting Gating System	20

2.6	Surface Plot of Fluid Temperature in Six Runner Type Design	21
2.7	Surface Plot of Fluid Temperature in Four Runner Type	21
2.8	Evaluate of Chill Vent Performance	22
2.9	Flat Runner-Gating System	23
2.10	Spoon Fed Gating System	23
2.11	Microstructure Shrinkage porosity (a) Flat Gating System (b) Spoon Fed Gating System	24
2.12	Total US Magnesium Casting Shipment for All Market	25
3.1	Conceptual Design Flowchart	31
3.2	Air Vents for Modified Design	34
3.3	Overflows of Conventional Mold Design	35
3.4	Test Piece Design	35
3.5	Runner of Conventional Mold Design	36
3.6	Conventional Mold	36
3.7	Solver Setting	38
3.8	Model Parameter Setting	39
3.9	(a): Properties Setting of Magnesium (b): Properties Setting of Magnesium	39

3.10	Properties Setting of Mold	40
3.11	Injection Speed of Molten Metal	41
3.12	Initial Temperature of Molten Metal	41
3.13	Preheat Temperature of Die	42
3.14	(a): Outlets Setting (b): Outlets Setting	42
4.1	Test Piece Modified Mold Design	45
4.2	Fan Gate	47
4.3	Tangential Gate	47
4.4	Conventional Mold Design of Test Piece	49
4.5	Skewness Metrics Graph of Conventional Mold Design	49
4.6	Element Quality Graph of Conventional Mold Design	49
4.7	Outward Curvature Runner with Air Vents	50
4.8	Skewness Metrics Graph of Outward Curvature Runner with Air Vents Mold Design	50
4.9	Element Quality Graph of Outward Curvature Runner with Air vents Mold Design	50
4.10	Flow of Molten Metal in Conventional Mold Design	52

4.11	Flow of Molten Metal in Outward Curvature Runner with Air Vents	53
4.12	Shot Profile of a Die Casting Process	54
4.13	Magnesium Metal Injection Molding	55
4.14	Conventional Type and V-LINE® Direct Casting	55
4.15	Velocity Streamline of Conventional Mold Design	57
4.16	Total Temperature Contour of Conventional Mold Design	58
4.17	Velocity Streamline of Outward Curvature Runner with Air Vents Mold Design	59
4.18	Total Temperature Contour of Outward Curvature Runner with Air Vents Mold Design	59
4.19	Side View of Velocity Streamline (a) Conventional Mold Design (b) Outward Curvature Runner with Air Vents Mold Design	61
4.20	Front View of Velocity Streamline (a) Conventional Mold Design (b) Outward Curvature Runner with Air Vents Mold Design	61
4.21	Surface Defects	62
4.22	(a) Test Piece, (b) Conventional Mold CT Scan (c) 16mm Thickness Probe Position	63
4.23	Surface Total Temperature Distribution of Conventional Mold	64
4.24	Surface Total Temperature Distribution of Outward Curvature Runner with Air Vents Mold Design	64

4.25	Inner Total Temperature Distribution of Conventional Mold	65
4.26	Inner Total Temperature Distribution of Outward Curvature Runner with Air Vents Mold Design	65
4.27	Front and Side View of Total Temperature Distribution of Magnesium, Conventional ADC12	66
4.28	Velocity Distribution of Difference Plunger Speeds (a)1.5m/s(b)2m/s(c)3m/s	67
4.29	Air Entrapment when Shot Velocity is Too Low in the Backward Reflected Wave	68
4.30	Air Entrapment when Shot Velocity is Too High in the Backward Reflected Wave	68
4.31	Timesteps against Total Pressure Graph for Atmospheric Pressure	69
4.32	Timesteps against Total Pressure Graph for Vacuum Pressure	69

LIST OF ABBREVIATIONS

A	Area
ADC 12	Aluminium Alloy
AM50A	Magnesium Alloy Type 2
AZ91D	Magnesium Alloy Type 1
CAD	Computer Aided Design
CFD	Computational Fluid Dynamic
FEA	Finite Element Analysis
HPDC	High Pressure Die Casting
MIM	Metal Injection Molding
MPa	Mega Pascals
MRI153M	High Creep Resistance Magnesium Alloys
MRI230D	Magnesium Alloy Type 3
UTS	Ultimate Tensile Strength (Pa)
Q	Volume Flow Rate (m ³ /s)
YTS	Yield Tensile Strength (Pa)

e	Specific Energy (J/kg)
k	Specific Kinetic Energy (J/kg)
pv	Specific Flow Energy (J/kg)
q	Specific Heat (J/kgK)
Re	Reynold Number
u	Specific Velocity (m/kgs)
w	Specific Work Done (J/s)

CHAPTER 1

INTRODUCTION

1.1 Background of Study

Die casting is a manufacturing process of metal products by injection of molten metal into the mold cavity with high pressure, then the molten metal was left in the cavity till solidified and finally ejected out from the cavity as a product. Die casting is majorly applicable for a non-ferrous and high variety of products (Ravi, 2011). High Pressure Die Casting (HPDC) and High Vacuum Die Casting are some examples of the die casting process. HPDC is widely adapted in die casting manufacturing industries due to their ability to manufacture thin to medium wall thickness product. HPDC process is highly recommended among die casting industries due to its cost-effective process and high production rate benefits. HPDC also served for the manufacture of plastics products (Moscovitch et. al, 2006).

The raw material uses for metal injection molding process is initially in granular size. The metal or plastics granules are then loaded into the feeder and transferred into a cylindrical shape with the aid of screw that will push the fluid at high pressure approaching the nozzle for injection. The metal granules are heated in the cylinder at high temperature and turn into molten metal. Metal granular is injected with high pressure and temperature to ensure solidification process takes place inside the cavity (Lohmüller Et al., 2003).

According to Rosof (1989), there are four basic steps in the metal injection molding process: mixing, molding, debinding and lastly sintering. In the mixing process, the fine metal powder will be mix with binders in the ratio of 1:1 before undergoes injection molding process. The molten metal then will be injected into two half mold clamp together. After the molten metal solidified, the product will be ejected out from the

mold cavity together with the runner, overflows and air vents. The finishing process such as assembly, milling, polishing or drilling will fall on the secondary process (Rosof, 1989).

The thixomolding method is an advanced method in die casting according to Energy Efficiency and Renewable Energy (EERE), (n.d.). The thixomolding method had replaced the traditional method of die casting, which lead to a higher production rate, lower manufacturing waste, and better workplace material handling. Figure 1.1 show schematic drawing of Thixomolding:

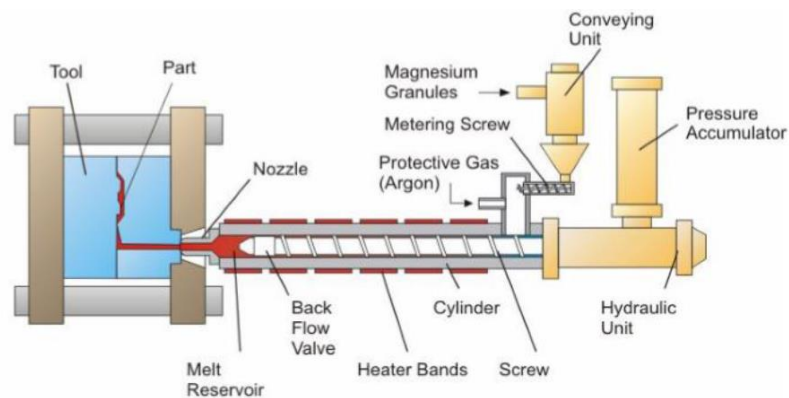


Figure 1.1: Schematic Drawing of Thixomolding® Machine (*Kainer, K. U. (ed.), 2003*)

Table 1.1 shows the components inside an injection molding machine and its function:

Table 1.1: Main Components and Function of Thixomolding

Component	Function
Feeder	- Load metal granules
	- Transfer granules to the cylinder
Screw	- Transfer granule to the nozzle at cylinder front
	- Has valves to prevent backflow
Cylinder	- Heat up metal granules to molten metal
Nozzle	- Inject the molten metal to the mold cavity

1.1.1 Market Demand on MIM Machine

Figure 1.2 shows the growing demand for metal injection molding (MIM) process over the years. The metal injection molding demand is higher in manufacturing of medical and industrial parts. The growth of metal injection molding products in automotive industries is due to the demand for lightweight and sustainable materials parts (Grand View Research, 2016).

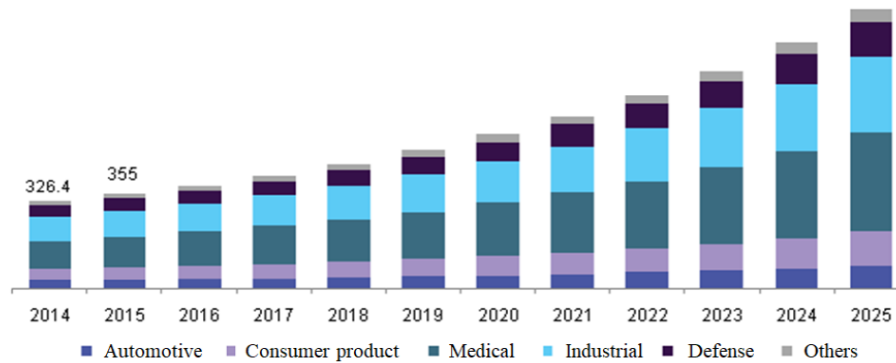


Figure 1.2: U.S. MIM Market by End-use, 2014 - 2025 (USD Million) (*Grand view Research, 2016*)

Figure 1.3 shows the metal injection molding demand in the Asia Pacific. A high percentage of the metal injection molding demand in the production of consumer product, automotive parts and industrial use due to industrial revolution and technology advancement. The growth of the demands had also benefited the Growth Domestic Product (GDP) and estimated to increase until the year 2025 (Grand View Research, 2016).

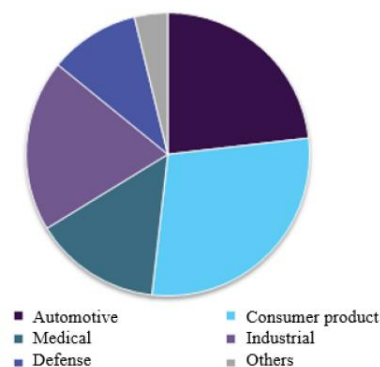


Figure 1.3: MIM Market Share by End-use on the Year 2015 (*Grand view Research, 2016*)

1.1.2 Magnesium Metal and Alloys

According to research and previous studies, the usage of Magnesium had expanded from aerospace, automotive parts to small and difficult components, hardware, and casing. Magnesium is used to manufacture military craft and as nuclear development back in World War I and II era (Mordike and Ebert, 2001). The excellent physical properties of magnesium such as lightweight making it suitable for hand-held carry and reduce the weight of high-speed transportation.

Study on a comparison between Magnesium metal and Aluminium has been conducted. The growing demand in the usage of Magnesium alloy among manufacturers is due to its excellent fluidity behaviors, that has better resistance towards hydrogen peroxide, resulting low casting defects compare to aluminum and copper (Luo,2013). Other than that, Magnesium alloy is eleven times easier to be cast compare to Aluminium alloys, this has led to a high production rate and low manufacturing cost (Fallis, 2013). The lower melting points of aluminum cause higher temperature required to preheat the aluminum granules before being injected into the mold cavity. Aluminum also has lower solidus temperature which causes a lower solidification rate, lead to the long manufacturing process. Thus, the production of Magnesium die-cast product could be the new market demand.

Magnesium alloys are a mixture of Aluminium, Iron and Manganese. Manganese is used to prevent corrosion and provide better binding. Manganese compound will later be separated during the melting process; thus, this alloy is safe to be consumed by humans (Luo, 2013).